

Date: Thursday, 01/05/2008 4:16:43 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HEAD REST
<b>Job Number</b> : 38972	
<b>Estimate Number</b> : 10423	
<b>P.O. Number</b> :	<b>Part Number</b> : D33033
<b>This Issue</b> : 01/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3303 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28126	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/05/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08-5-02</u>	
<b>Comment</b> : Est:A 04.09.07 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



3.7



**Comment:** Qty.: 0.3135 sf(s)/Unit Total : 3.1353 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch:

107572

HB 8-5-7

107572

HB 8-5-13

~~HB~~ ALO

2.0	WATER JET
-----	-----------

B  
B

FLOW WATER JET

HB 8-5-7  
HB 8-5-13

**Comment:** FLOW WATER JET

3.0	QC2
-----	-----

HB 8-5-13  
HB 8-5-7

INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8
-----	-----

SECOND CHECK  
50860513 (ALO)

**Comment:** SECOND CHECK

50860513 (ALO)

5.0	SMALL FAB 1
-----	-------------



SMALL &amp; MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

HB 8-5-7

2- C'sink nut plate holes as per Dwg D3303

3-polish waterjet marks

Jml 08/05/13 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/15	#							

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:43 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 38972

Part Number: D33033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



To fit DT9011



(P12)

Comment: NC BRAKE

Form as per Dwg D3303

~~To fit D33033 Part~~

1500-05.13

80 08/05/13

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/14

(X10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

20/12 08/05/14

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08-05-14

(X10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

#38969

AS 08/05/14

(X10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



U 08/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3303-3 PAR #: N/A Fault Category: Prod / Prod Ass <sup>in ede small</sup> NCR: Yes No DQA: AD Date: 08/05/14  
 QA: N/C Closed: AD Date: 08/05/15

NCR: <u>38912</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/13	# 6.0	10 parts broke/cracks During Bending nos to fit on pt 901)	<i>[Signature]</i>	Scrap and Destroy and <del>Replaced</del> Replace Qty <u>(10)</u> B# <u>107572</u>	<i>[Signature]</i> 08/05/13	<i>[Signature]</i> 08/05/13	<i>[Signature]</i>	<i>[Signature]</i> 08/05/13

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38972
<b>Description:</b> Head Rest		<b>Part Number:</b> D3303-3
<b>Inspection Dwg:</b> D3303	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

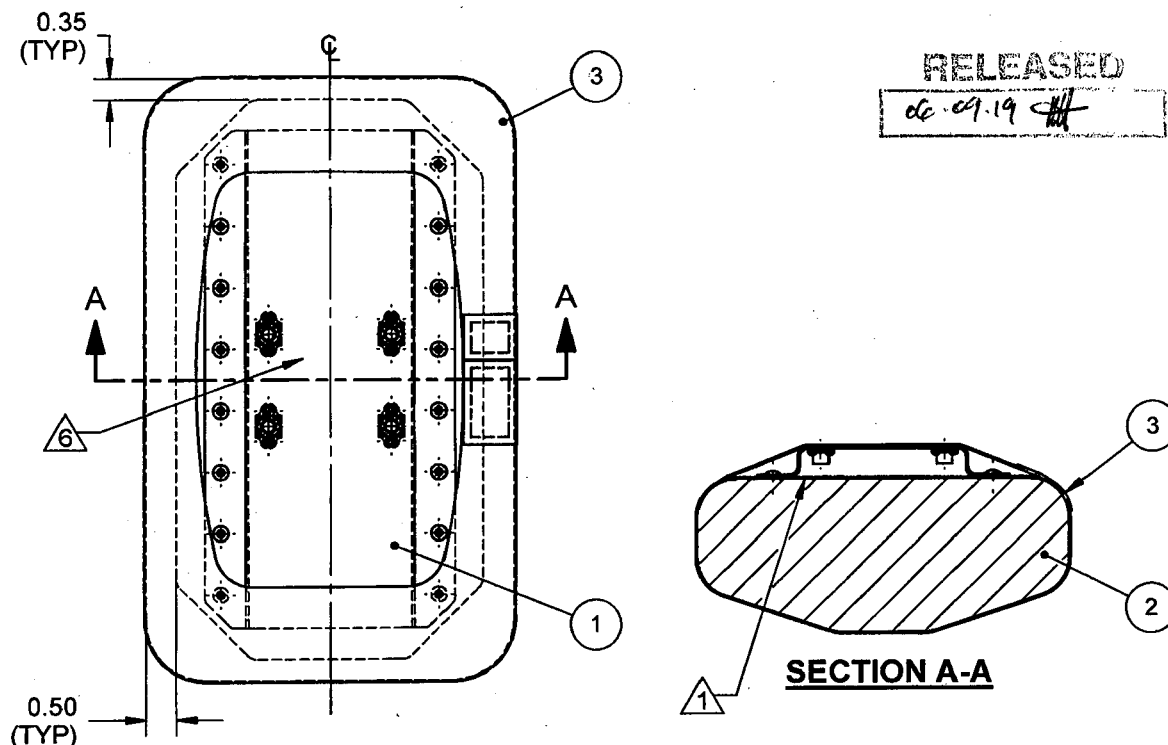
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.850	+/-0.010	4.853	x			
4.330	+/-0.005	4.333	x			
0.550	+/-0.010	.549	x			
0.260	+/-0.010	.261	x			
3.300	+/-0.010	3.300	x			
1.500	+/-0.005	1.498	x			
0.250	+/-0.005	.250	x			
Ø0.219	+0.005/-0.000	.218	x			
Ø0.098	+0.005/-0.000	.099	x			
Ø0.128	+0.005/-0.000	.130	x			
R0.12	+/-0.030	.12	x			
2.000	+/-0.005	1.999	x			
1.425	+/-0.010	1.425	x			
0.44 x 45°	+/-0.030	.44	x			
8.100	+/-0.010	8.100	x			
7.000	+/-0.005	6.997	x			
1.000	+/-0.005	1.000	x			
0.040	+/-0.010	.039	x			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-5-7	<b>Date:</b> 08/05/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	[Signature]

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 1 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>		SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

**NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

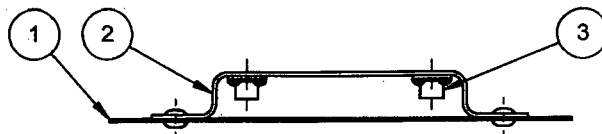
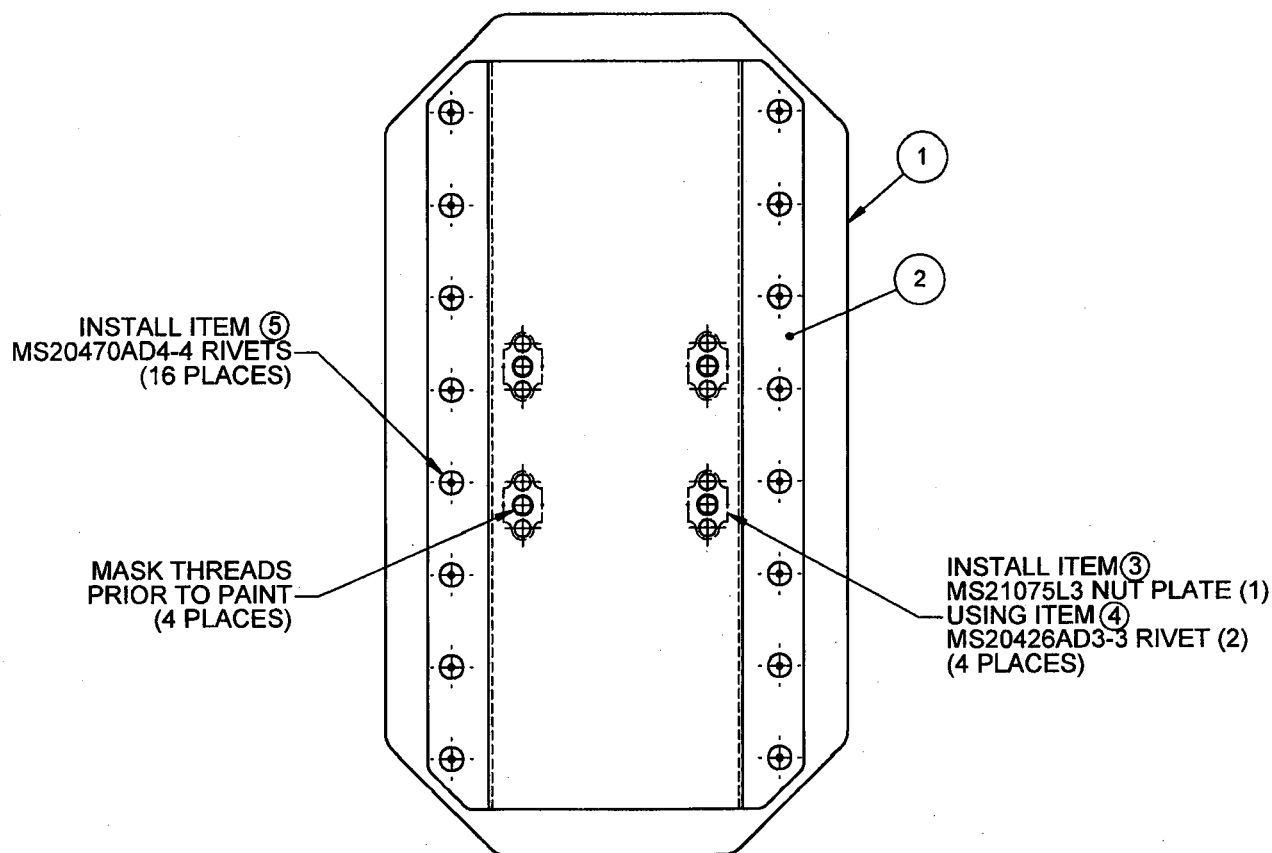
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DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2



RELEASED

06.09.19 *[Signature]*

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

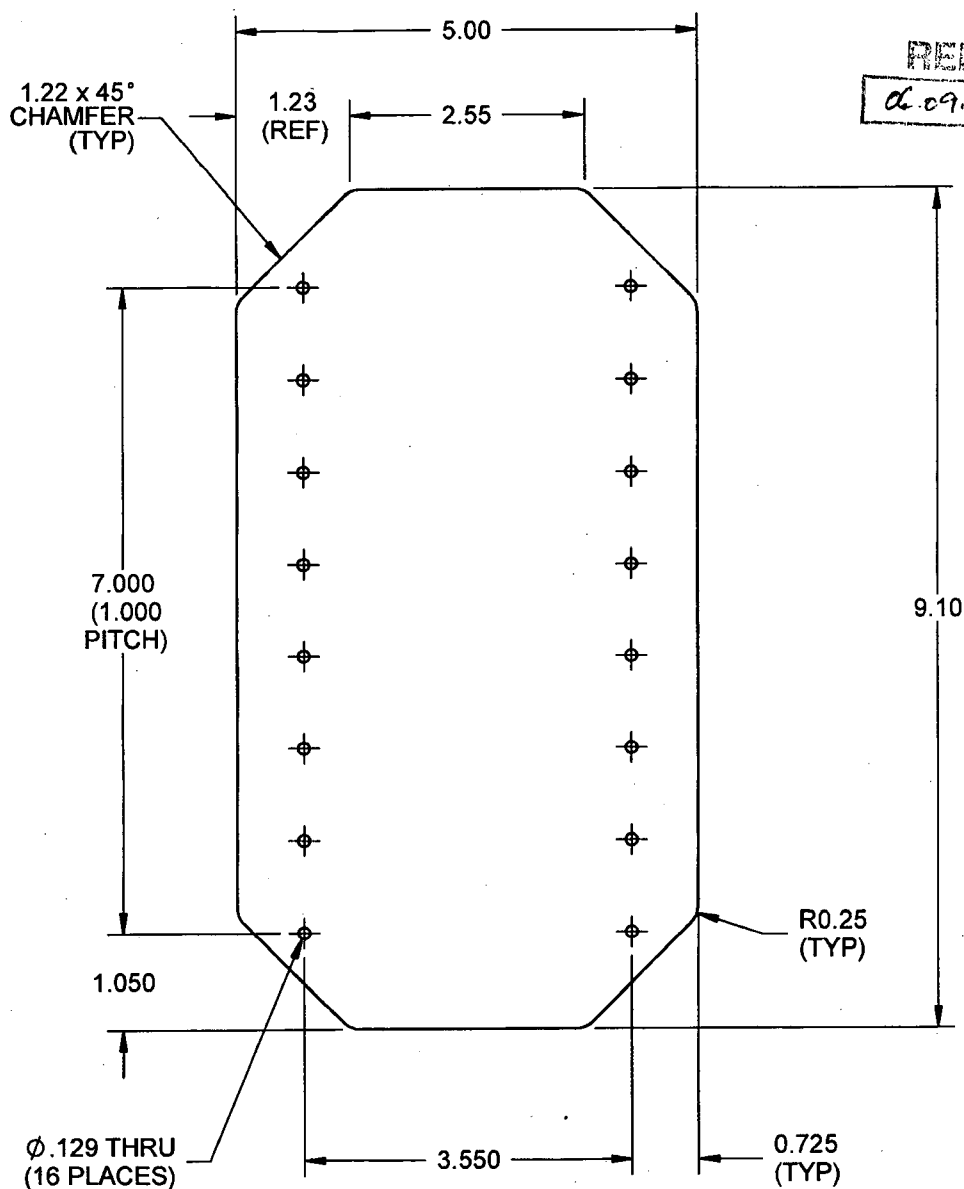
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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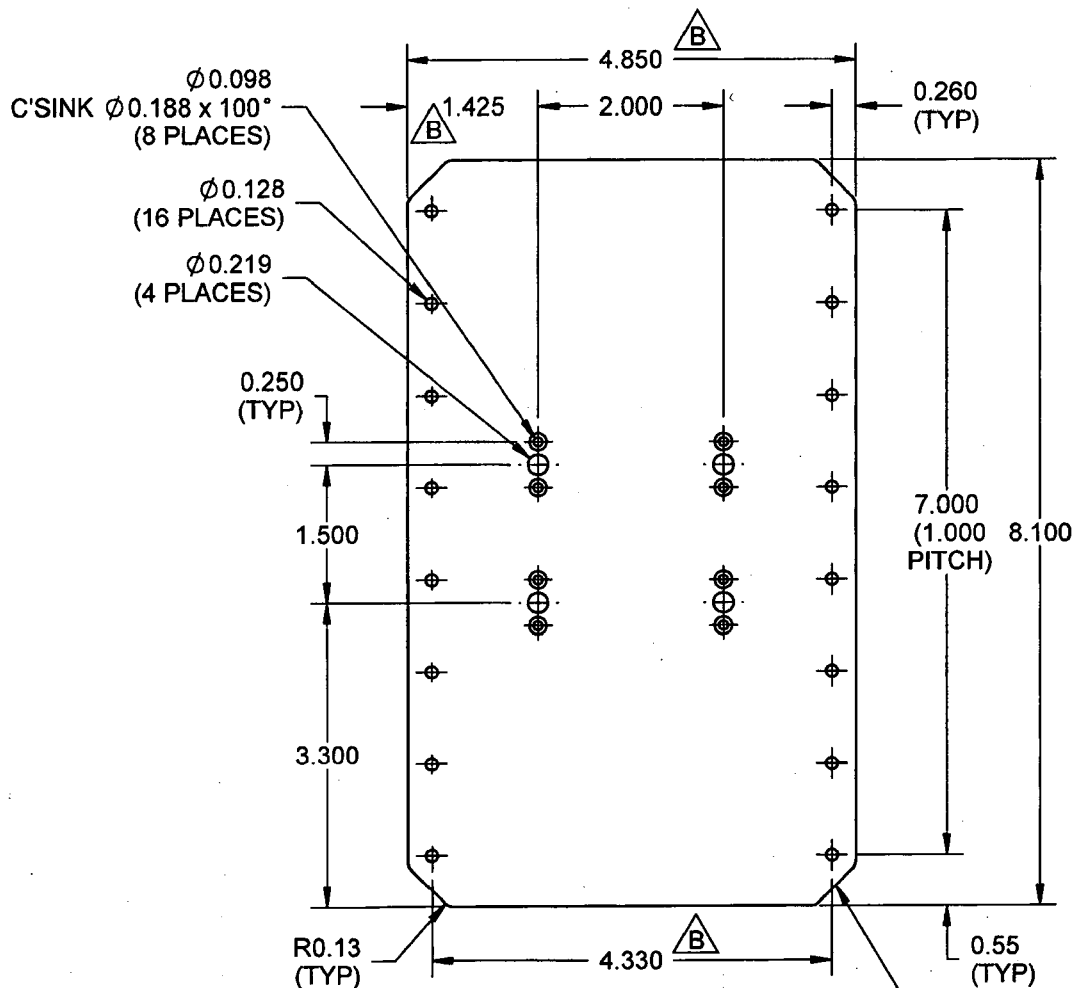
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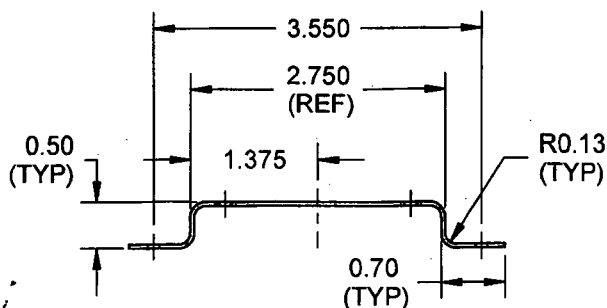
**DART**

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>B</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 4 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2

**D3303-3F BRACKET FLAT PATTERN**

RELEASED  
06-09-19

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**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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